

Alusol RAL BF

High performance semi-synthetic metalworking fluid

Description

Castrol Alusol™ RAL BF is a high performance semi synthetic metalworking fluid which is boron and chlorine free. It contains a unique additive package that works in synergy to enhance machining performance and surface finish, provide excellent product stability, improve bio-resistance properties and lower the overall operations costs. Alusol RAL BF is suitable for large central systems and single sump machines.

Application

Alusol RAL BF is especially designed for machining of aluminium alloys. The product can also be used for machining of low-medium alloyed steel.

	Cast Iron	Low-medium alloyed steel	High alloyed - stainless steel	Aluminium alloys	Magnesium alloys	Yellow
Grinding		ü	ü	ü		
Milling, Turning (general machining)	ü	ü ü	ü	ü ü ü		
Drilling	ü	ü ü		ü ü ü		
Reaming, Tapping	ü	ü ü		ü ü ü		
Broaching				ü ü ü		

Advantages

- Boron free for environmental compliance and improved residue characteristics
- Chlorine and nitrite free to fulfill your local legislation, waste treatment and environmental requirements
- Resists fungal and bacterial attack to extend fluid life and reduce maintenance and machine downtime
- Low foam in recommended water conditions
- Lubrication package specifically designed to enhance tool life and improve surface finish in aluminium machining
- Excellent wetting properties reduce coolant drag out and deliver clean machine tools and components

Typical Characteristics

Name	Method	Units	Value
Concentrate			
Appearance	Visual		Amber
Mineral oil content	Calculated	Wt%	44
Emulsion			
Appearance	Visual		Milky
pH (6%)	DIN 61369 ASTM E70-97		9.0
Refractometer Factor			1.0

Recommended Concentrations

Grinding	6-7%
General Machining	6-8%
Drilling	7-9%
Reaming and tapping	8-10%
Broaching	8-10%

Water range 100-800 ppm CaCO₃

Additional Information

	Boron	Formaldehyde releasing agent	EP-Ester	Amines	Chlorine
Additives	-	ü	ü	ü	-

Storage

To avoid product deterioration, keep the container/drum tightly sealed always. Prevent any frost and water ingress. Store it in a cool and dry place away from direct sunlight. It is preferable to store the product indoors always. For more details, please refer the product safety data sheet.

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